Work Orde									Geis Page 1			
Revision ID:	D3213-3 Door Panel			Accept				s	Setup St	1 1 8 8 1 5 1 4 1		
Start Date: 1 Required Date: 1 Reference:	1/6/2011 1/14/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item 1 Customer:	I D:				1 18311181		
	Process Plan	n:	Date://-0/- / Date:	Tooling: SPC (Y/N):		ate:		F		tart	1844 18 18 188 1111 111 111 111	
Sequence ID/ Work Center ID		Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revi	ision Nbr				_ 						
D3213	Rev	Α										
Waterjet FLOW CNC Waterjet 7004. CCS		FLOW WATER JET Memo	A	0.00				R 11	- <u>1- 10</u>	<u> </u>		
QC Quality Control		QC2- Inspect parts of Memo	f machine FAI/FAIB	0.00				B(1-	1 <u>-1()</u>			
120 QC Quality Control		QC8- Inspect parts - s	second check	0.00	<u>//-</u> 0			. 46		·		

Work Order ID 65143

Thursday, January 06, 2011 3:29:44 PM



Page 2

Item ID:

D3213-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Door Panel

Start Date:

Required Date: 1/14/2011

1/6/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ QC:

Date: _____

Date: _____

Tooling:

SPC (Y/N):

Date: Date:

Tool # Plan

Code

Accept

Qty

Start

Stop

Reject

Number Stamp

Insp.

Reject

Qty

Run

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

0.00

0.00

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

olochy

X 6

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Memo

0.00

6 BR 11-01-11

Work Order	ID	65 1	143
Thursday, January	06, 20	11 3	3:29:44 PM



Page 3

Item ID:

D3213-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Door Panel

Start Date: 1/6/2011 Start Qty: 6.00

Required Date: 1/14/2011

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

				,		
А	DI)r	οv	a	S	:

Process Plan:

Operation

Description

Date:

Date:

Tooling:

Date:

Run

Start



SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/

Work Center ID

160

Packaging

Memo

Run Hours Identify as per dwg & Stock Location: 5/ 2

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

0.00

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/12 TV)
MA
(1-01-11

Picklist Print

Thursday, January 06, 2011 3:30:15 PM

Work Order ID: 65143

Parent Item:

D3213-3

Parent Item Name: Door Panel



Start Date: 1/6/2011

Required Date: 1/14/2011

Page 1

Start Qty: 6.00

114351

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 05-11-17 JLM

IPP Rev:B

Now on Waterjet 07-02-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063	111 210 10 11 011 11 0 0110 0 1100 1111	Purchased	No			100	sf	70.5000	0.4714	2.977263			
										ın ı	1 - 43		

2024-T3 .063 sheet

Location	Loc Qty	Loc Code
MAT22	70.5	
114351	70.5	



DART AEROSPACE LTD	Work Order:	65/4/3
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Tolerance Dimension Accept Reject Method of Inspection		,								
0.300		Tolerance		Accept	Reject		Comments			
0.300 +/-0.010 、うらん > V 1802 14.400 +/-0.010 14、400	15.00	+/-0.030	15,00	¥.		TB01				
14.400	0.300	+/-0.010		1 '						
20.128	14.400	+/-0.010	1	79						
4.42 +/-0.030 4, 4, 2, 1 V 1.00 +/-0.030 ,995 W 0.300 +/-0.010 ,999 Y Pitch 2.057 +/-0.005 } .060 > V	Ø0.128	+0.005/-0.001	-	*		V				
1.00 +/-0.030	4.42	+/-0.030		1 '		V				
0.300 +/-0.010 3999 > V Pitch 2.057 +/-0.005 } .060 > V	1.00	+/-0.030		I.		1				
Pitch 2.057 +/-0.005 } .060 > //	0.300	+/-0.010		!		γ				
	Pitch 2.057	+/-0.005	,			1/				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-1-15	Date: U/O//(C)	Date:	N/A

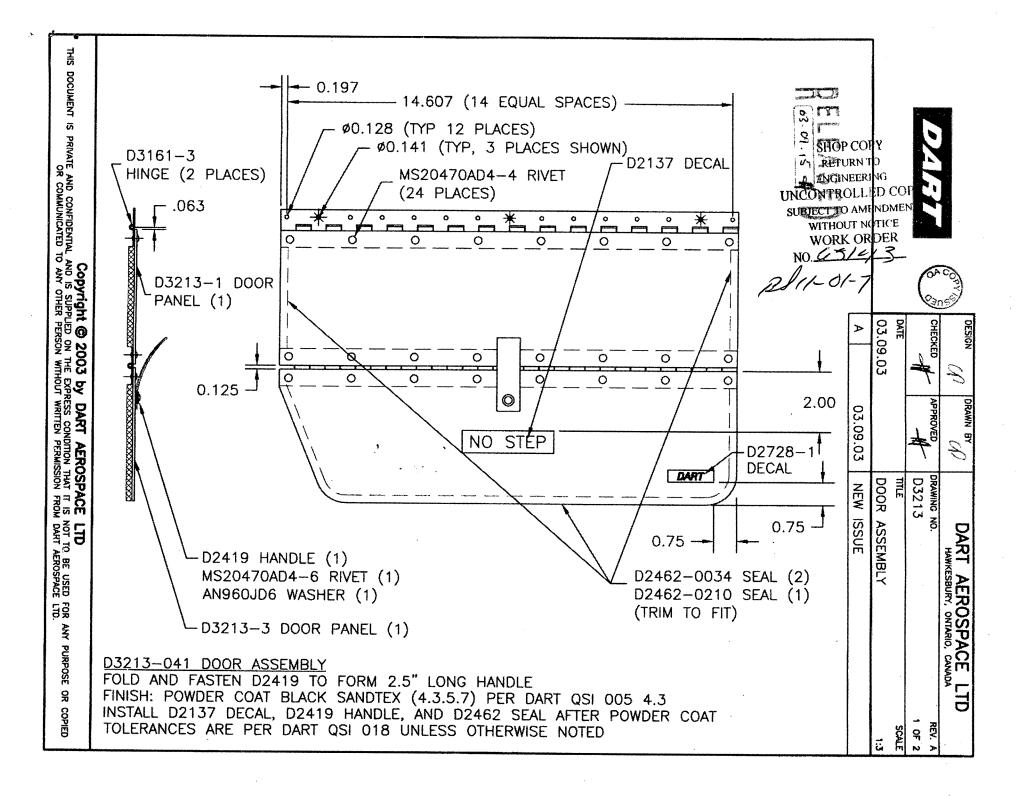
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
В	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	
С	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC	N

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGE	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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						•				
		PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:					
	R	esolution:	Disposition: QA: N/C Closed: Dat					Date: _		
NCR:			WORK ORDE	ORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC		on B Sign &		cation	Approval	Approval		
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sect	tion C	Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

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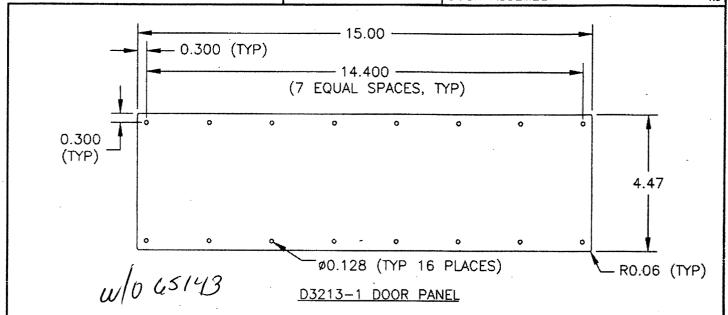
Dart Ae	rospace	Ltd								<u>. 5 a</u>		
W/O:			W	ORK ORDER CHANGI	ES							
DATE	STEP	PRC	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No			Fault Category: NCI			NCR: Yes No DQA: Date:						
	Resolution:			Disposition: Q			QA: N/C Closed: Date:					
NCR:			WORK OR	DER NON-CONFORMA	NCE	(NCR)					
	0777	Description of NC	Corrective Action Section B				Verific	ation	Approvai	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector		
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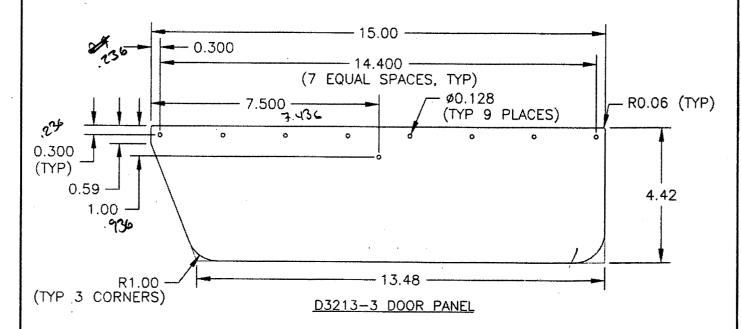
NOTE: Date & initial all entries





	DESIGN (A)	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO	
)	CHECKED M	APPROVED	DRAWING NO.	REV. A
′	d	AL AL	D3213	2 OF 2
	DATE		TILE	SCALE
	03.09.03		DOOR ASSEMBLY	1:3





D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	ES							
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector			
Part No:		PAR #:	Fault Category: NC			NCR: Yes No DQA:						
	R	esolution:	Disposition: Q			A: N/C Closed:						
NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			Verification Section C			Approval QC Inspector			
		Section A	Chief Eng	Chief Eng	Date		etion C	Chief Eng	QC inspector			
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NOTE: Date & initial all entries

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